

Date: Thursday, 11/06/2009 12:50:40 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE ASSEMBLY 27"
Job Number : 48508	
Estimate Number : 11191	
P.O. Number :	Part Number : D3298003
This Issue : 11/06/2009 S.O. No. :	Drawing Number : D3298 REV A2
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : A2
Previous Run : 47503	Material :
Written By :	Due Date : 19/06/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JULIE DAWSON</u>	
Comment : Est A04.09.02 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0375W035	6061-T6 RD Tube .375 x.035W
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Comment: Qty.: 2.3625 f(s)/Unit Total: 23.6250 f(s)

Cut tube to length as per Dwg D3298

Material: 6061-T6 (WW-T-700/6) tubing Ø0.375" x 0.035" wall (M6061T6T0.375W.035)

Identify as D3298-003

Batch:

M104913 (6X)

M104921 (3X)*

M-1 09/06/17
M104913 (1X)

2.0	MS208196D	Sleeve
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Sleeve

Pick:

Qty	Part Number	Description	Batch
2	MS20819-6D	Sleeve	

M110916 (8X)

M112082 (12X)

M-1 09/06/18

3.0	AN8186D	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Coupling Nut

Pick:

Qty	Part Number	Description	Batch
2	AN818-6D	Nut	

M108940* (2X)

M112082 (18X)

M-1 09/06/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY 27"

Job Number: 48508

Part Number: D3298003

Job Number:



Seq. #: Machine Or Operation: Description :

4.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



(Tox)

Comment: SMALL & MEDIUM FAB RESOURCE 1

Bend tube as per template D3298-003T1 & Dwg D3298

Flare end as per Dwg D3298.

Ensure that sleeves and coupling are installed first

M-h 09/06/18

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/06/19 (x10)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



(10)

Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 195

9/6/19

Se1

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 09-06-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 04.07.06		TITLE TUBE ASSEMBLIES	SCALE NTS
A	04.07.06	NEW ISSUE	
A1	<i>[Signature]</i> 04.11.30	CORRECT VIEW D3298-003; 16.50 WAS 15.75	
A2	<i>[Signature]</i> 05.05.06	FOR D3298-001/-003 16.00 WAS 16.50	

RELEASED
04.07.09 *[Signature]*

P/N	TEMPLATE	CUT LENGTH OF TUBE	MS20819-6D SLEEVE	AN818-6D NUT	DESC.	MATERIAL
D3298-001	D3298-001T1	25.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-003	D3298-003T1	27.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-005	D3298-005T1	23.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-007	D3298-007T1	8.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-009	D3298-009T1	6.00	1	1	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-011	D3298-011T1	8.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-013	D3298-013T1	10.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-015	D3298-015T1	14.00	1	1	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)

Notes:

- (1) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.
- (2) TUBES TO BE FLARED 37° TO MATE WITH FITTINGS MADE TO MS33514.
- (3) ENSURE SEAMLESS TUBING IS USED.
- (4) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- (6) ALL DIMENSIONS ARE IN INCHES
- (7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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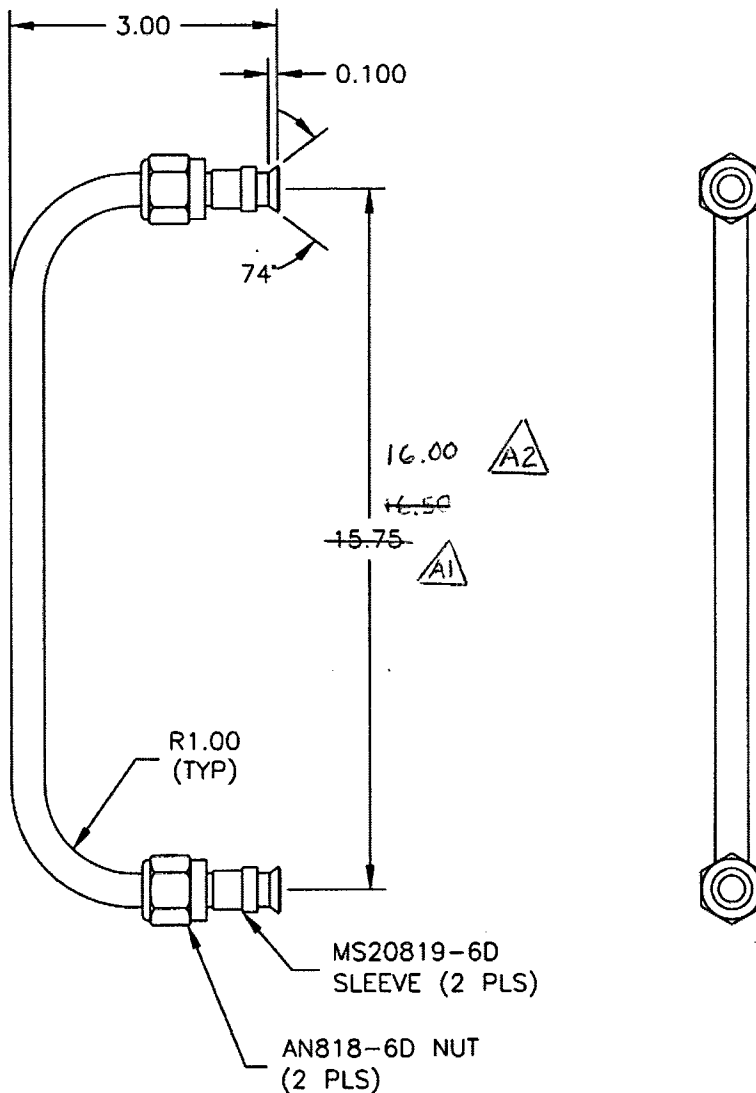
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04.09.06 JF



D3298-001

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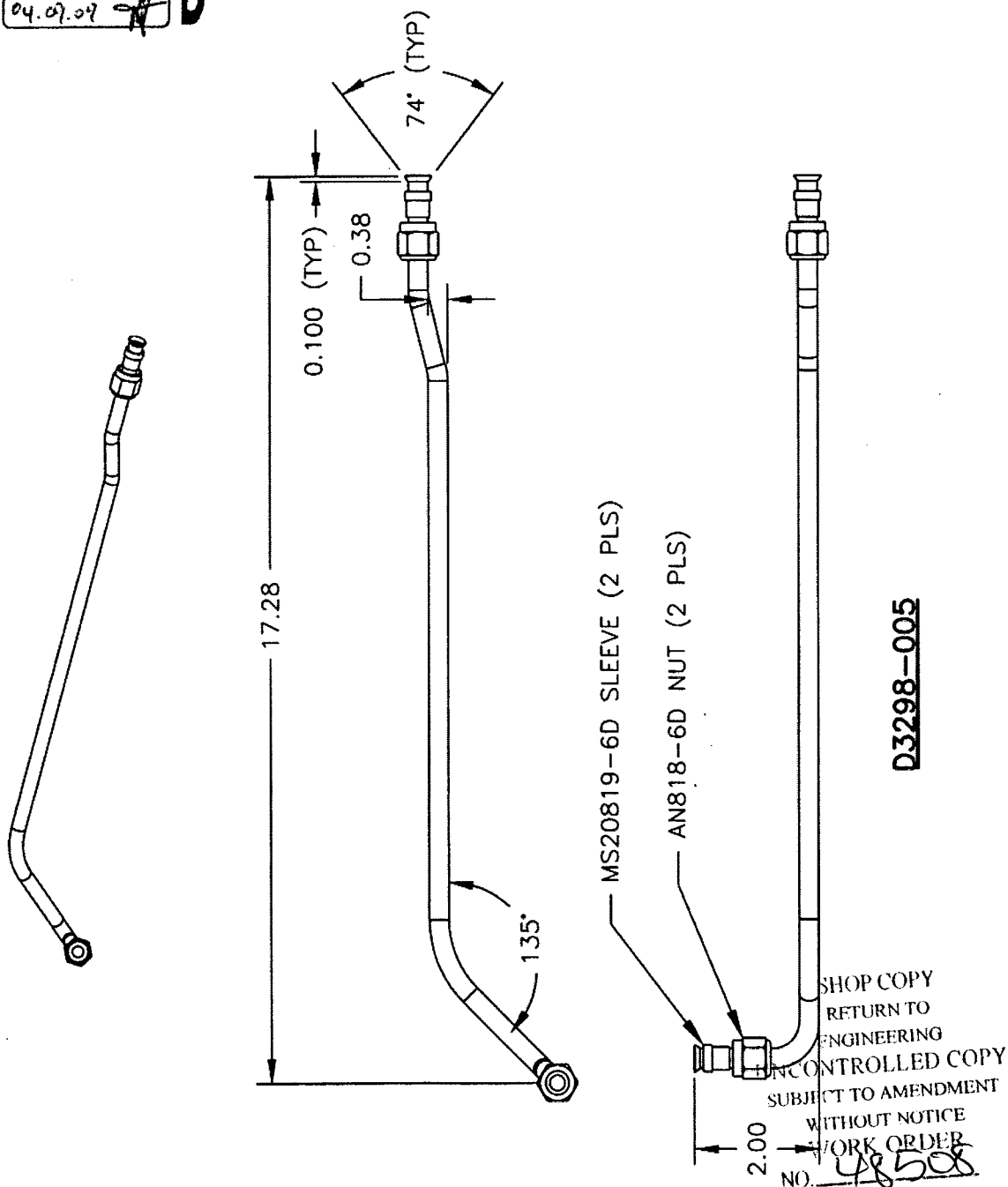
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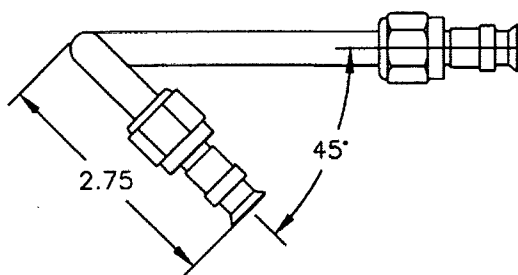
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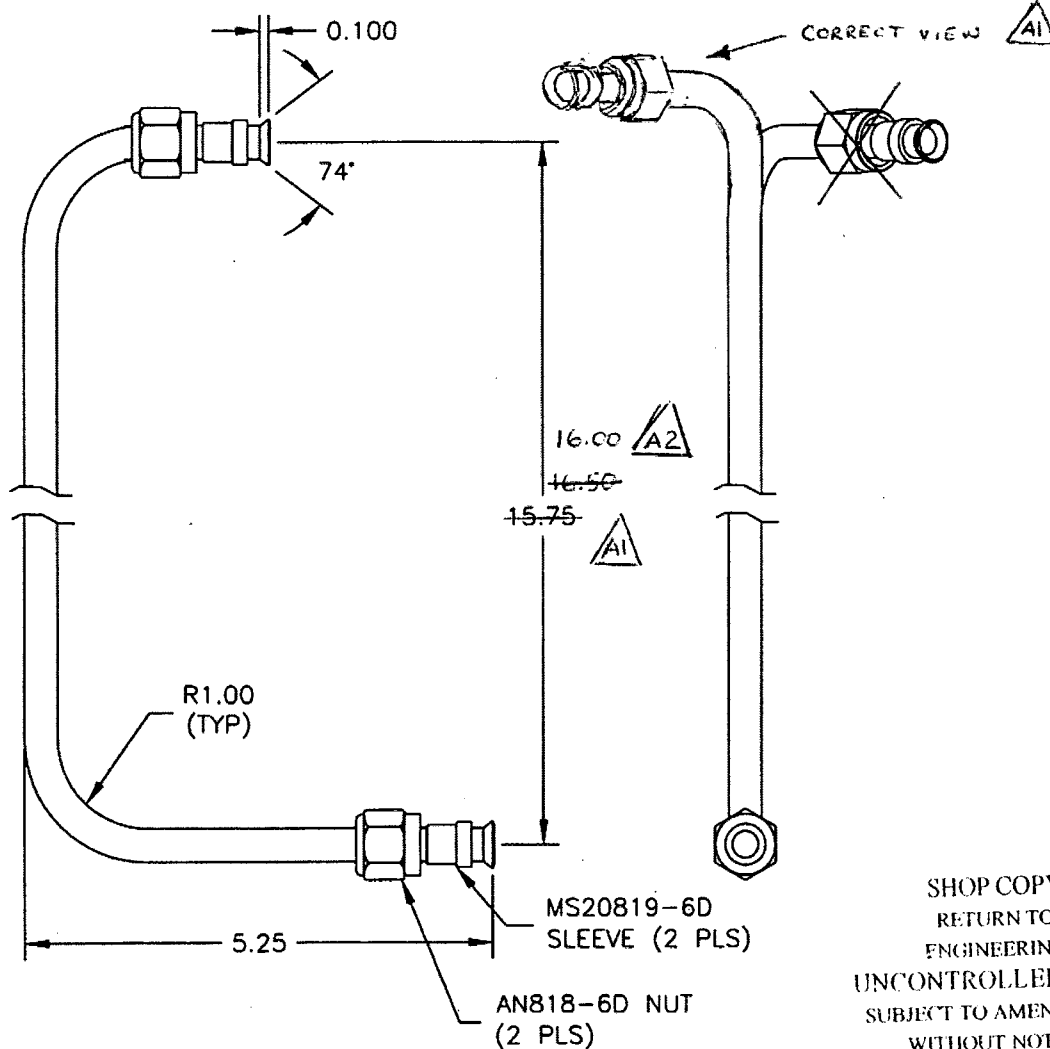


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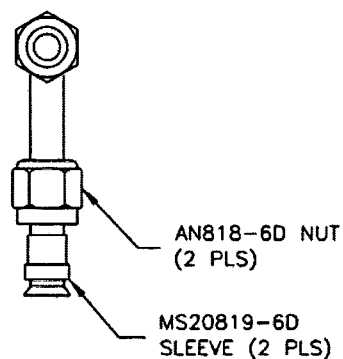
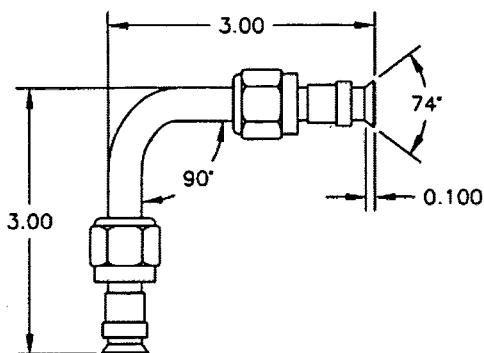
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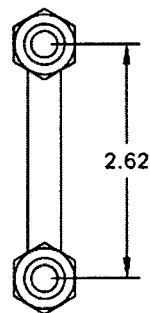
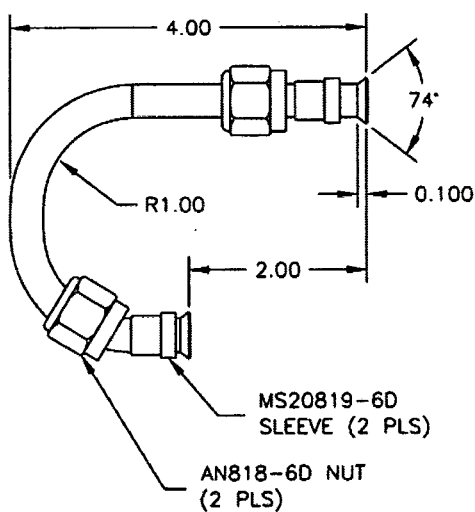


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D3298-013

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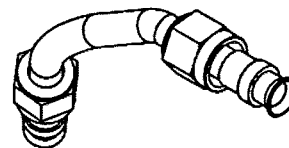
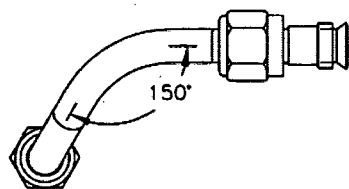
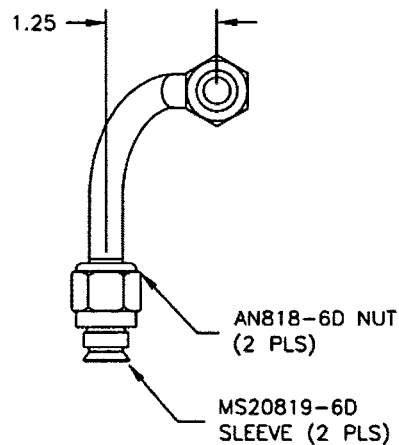
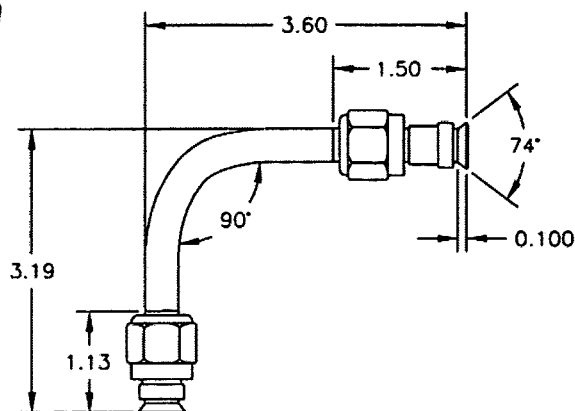
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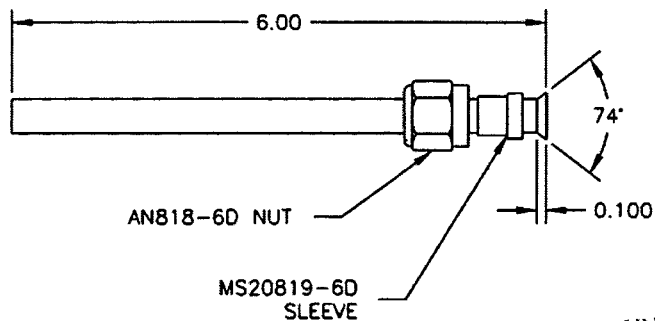


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D3298-009

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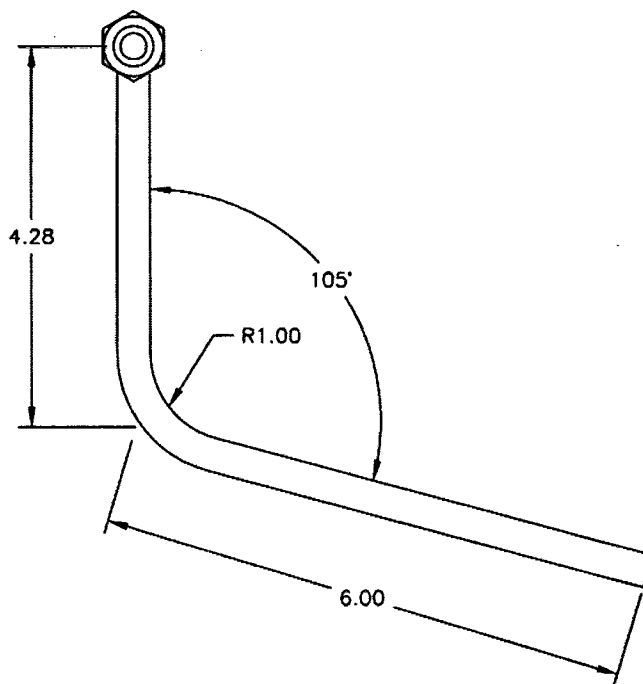
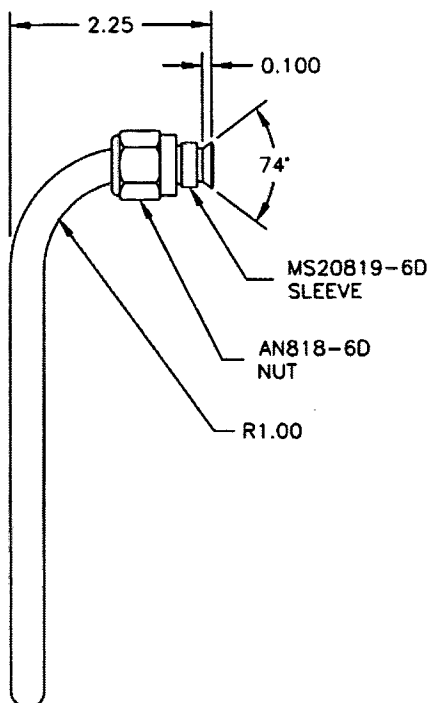
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D3298-015

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